

Work Order ID 81557-1

81557

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March 15, 2012 10:35:28 AM

Item ID: D2423

Revision ID:

Item Name: Lug Extrusion

Start Date: 3/15/12

Required Date: 4/06/12

Reference:

Approvals:

Process Plan: CL

QC:

Date: 12/03/15 Tooling:

Date: SPC (Y/N):

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2423

Rev B1

0.00

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 16455

Manufacture as per Dwg

Possible Supplier: SIGNATURE ALUMINUM

Material release note is required

0.00

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

0.00

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

CL 12/03/15 288

12/14/15 304

(436) 304
Lengths

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Item ID: D2423

Revision ID:

Item Name: Lug Extrusion

Start Date: 3/15/12 Start Qty: 288.00

Required Date: 4/06/12 Req'd Qty: 288.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

130

130

Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: _____

Memo

Set Up/
Run Hours

0.00

0.00

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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to Park 60 12/4/12

12/4/26

MS 12-04-26

Picklist Print

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Work Order ID: 81557

Parent Item: D2423

Parent Item Name: Lug Extrusion

Start Date: 3/15/12

Required Date: 4/06/12

Start Qty: 288.00

Required Qty: 288.00

Comments: IPP G04.09.02Part Number D2423-108 changed to D2423KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423P Lug Extrusion		Purchased	No			100	f	0.0000	1	288			

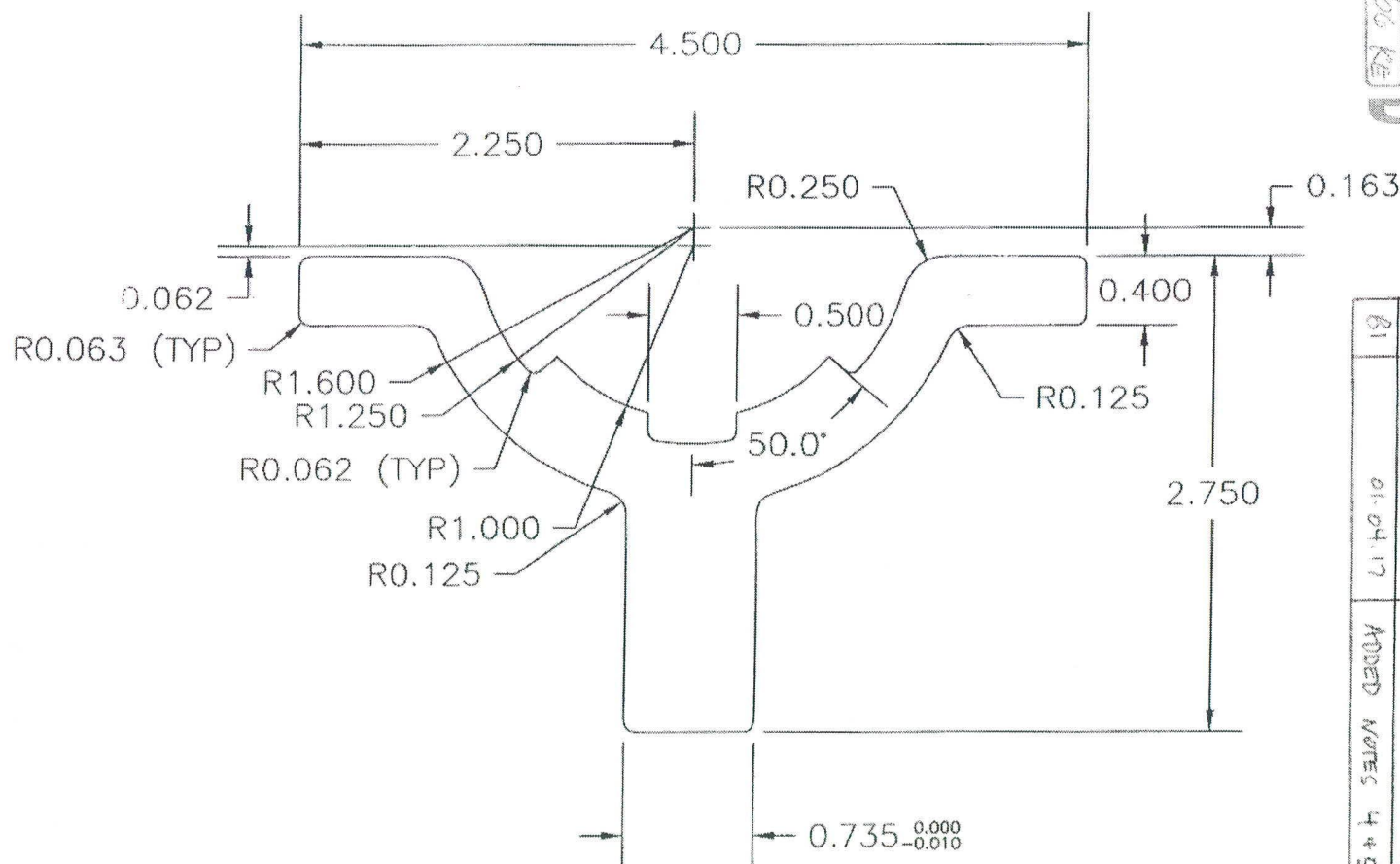
4/24/12 (38)

DART



RELEASED
9/30/06 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2423	SHEET 1 OF 1
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4+5	



C/L 12103/18
W/O: 81557

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARBON INDALEX DIE # M5-12866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

signature
aluminum
CANADA INC.

ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE / DATE DU BODEREAU
04-04-12

MANIFEST NUMBER / N° DE BODEREAU
005223

SALES ORDER NUMBER / N° DE COM
105032

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROS POUR TOUTE
CORRESPONDANCE

TERMS / FREIGHT

PP

SHIP TO / EXPÉDIÉ À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				SOLD TO / VENDUE À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				LOCATION PIC		TRAILER NUMBER / REMORQUE Nombre 5301		SALESMAN / VENDEUR 042		CREDIT REP / REP DU CRÉDIT 		SALES REP / REP. DES VENTES G.ATTENBOROU	
CUSTOMER ID / ID DU CLIENT 46024		ORDER DATE / DE LA COM 03/15/12		CUSTOMER PO NUMBER / CLIENT PO Nombre 16455				JOB / FICHIER 				FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU		CUST SERVICE REP / REP. SERVICE CLIENTELE DLB			
				BILL OF LADING NUMBER / NO. DE CONNAISEMENT 005223				CARRIER / TRANSPORTEUR JODEE									
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO CUSTOMER PART NUMBER / NUMÉRO DE RÉFÉRENCE DU CLIENT	ALLOY & TEMPER / ALLIAGE & TEMPER LENGTH / LONGUEUR CUTTING TOLERANCE / Tolérance de coupe	FINISH DESCRIPTION / DESCRIPTION DE FINITION FABRICATION DESCRIPTION / DESCRIPTION DE FABRICATION SHIPPING TOLERANCE / EXPÉDITION TOLERANCE		NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison					
001	1,109	LB		DAA-5-2	6061 T6			1	1,142	1,131	LB						
	503	KG		D2423P	96.0000 IN				518	513	KG						
	36	PC			Cut(+): 0.1180 Cut(-): 0.0000 Min: 0 % Max: 0 %					38	PC						
						811313 / 136110		1	1,142	1,131		38 PC					

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

		Continued	
TOTALS			

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
03/30/2012	5281214	105032	1
Cust PO	B/L No	Lot	Date
16455	005223	811313	04/04/12

Sold To		Ship To	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	
Item No	Part No	Item Description	Cust Part
001	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	1,142 LBS		
Net Qty	1,131 LBS	38 PCS	1 PKG
Specification		Die Desc	
AMS QQA 200/8 + ASTM B221		Srbuko	

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HREW
327.6 / 47.5	306.2 / 44.4	16.2	0.0	94

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.63	0.22	0.21	0.03	0.87	0.05	0.13	0.01	0.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc

